

DIN EN 16771:2017-03 (English)

Railway applications - Infrastructure - Aluminothermic welding of grooved rails

Contents		Page
European foreword		4
Introduction		5
1 Scope		6
2 Normative references		6
3 Terms and definitions		6
4 Information to be supplied by the railway authority		7
5 Approval procedure		7
5.1 General		7
5.2 Process identification		7
5.3 General requirements		7
5.4 Documents to be submitted with the request for approval		8
5.5 Initial compliance testing		9
5.6 Extension of initial compliance testing		11
5.7 Preparation and allocation of test welds		11
6 Re-approval following process changes		12
7 Laboratory tests		15
7.1 Visual surface examination		15
7.1.1 Ascast weld surface		15
7.1.2 Ground weld surface		15
7.2 Running surface hardness test		16
7.3 Slow bend test		16
7.4 Internal examination		17
7.4.1 Weld soundness		17
7.4.2 Fusion zone - Shape and dimension		19
7.4.3 Microscopic examination		19
7.4.4 Heat softened zone width		20
7.5 Chemical analysis		20
Annex A (informative) Steps in approval		22
Annex B (informative) Suggested sequence of laboratory tests		24
Annex C (informative) Procedure for FRY etching		25
Annex D (normative) Procedure for measurement of surface hardness		26
Annex E (normative) Procedure for slow bend test		27
Annex F (normative) Procedure for recording test weld fracture face defects		29
Annex G (normative) Ultrasonic inspection procedure on aluminothermic welds to be sectioned		30
G.1 Principle		30
G.2 Apparatus		30

G.3	Preparation of samples	30
G.4	Calibration	30
G.5	Testing	30
G.6	Reporting	31
Annex H (normative) Procedure for microscopic examination of the visible heat affected zone and fusion zone of welds		32
Annex I (normative) Procedure for measurement of the heat softened zone width		33
I.1	Measurement of hardness	33
I.2	Evaluation of hardness data	34
Bibliography		36